

Date: Tuesday, 1/3/2006 4:15:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 25357	
Estimate Number : 10036	
P.O. Number : N/A	Part Number : D6101013
This Issue : 1/3/2006 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25356	Material : N/A
Written By : _____	Due Date : 11/15/2006 Qty: 30 Um: Each
Checked & Approved By : _____	
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 00000339 06/01/04

a) Description: Alluminum billet

b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 10.100" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	D6101013	Saddle billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
 Saddle billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

06/04/29 (30)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

06/11/30 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 18 Date: 06/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25357

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/4/29 (30)

6.0

DC

DOCUMENT CONTROL



(30)

Comment: DOCUMENT CONTROL

Inspection Level 21

Box 11/30

Job Completion



Cy Cancel 11/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

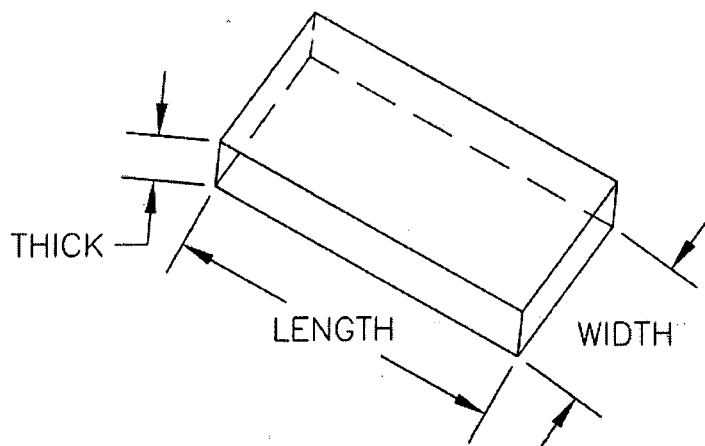
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



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PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99216
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4080392

CUSTOMER PO NUMBER: 01-83475		WORK PACKAGE:		CUSTOMER PART NUMBER: 6873 A97075-80			SHIP RUN/LOAD ID: 100828/18		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1042200		LINE ITEM: 1	SHIP DATE: 9-NOV-2006		ALLOY: 7075	CLAD: BARE	TEMPER: T7351		PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 7276 LB		QUANTITY: 4 PCS EST.		B/L NUMBER: 2010362		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 147.000 IN

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev06
BSS 7055/RevA
GSS16100/RevG
PS 21211/RevJ

AMS-QQ-A-250/12
ASTM B 594/Rev02
CSTI 006/RevC
MIL-STD-2154

AMS-STD-2154
BAC 5439/RevH
DPS 4.713/RevN/AmdAF
MMS 159/RevN

Test Code: 4297

Test Results

Lot: 378703A3 Cast 933

Drop 16

Ingot 1

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	89.9 : 70.0 (482 : 483)	58.3 : 58.7 (402 : 405)	10.8 : 11.6
		Conductivity %IACS :	42.4 Min	42.8 Max	
		(MS/M) :	24.6 Min	24.8 Max	

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.17	1.42	0.01	2.48	0.20	5.60	0.01	0.01	0.01	TOT 0.02

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
DATE REC'D 11.15.06 FAC 6873
APPROVED BY: [Signature]

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4080392

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A.
AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH
IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE.
TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER
ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE
PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO 9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poyner